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D407-558-045
Job Sheet 198608



Part No: D407-558-045

Job Qty: 1 pcs

Part Name: Single Mirror Installation



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/16/19

Description: ORDER 18117

Type: SOLD

Note: DWG REV D IPP Rev:A 09-01-15 new issue DD verified by:ec IPP Rev:B 10.06.17 added grommet DD
verf:EC IPP REV:C 11.01.19 AS PER chg002 DD VERF:EC IPP REV:D 12.04.04 AS PER chg003 DD
VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
110	Small Fab - 1	1 pcs	8/16/19	8/16/19	0.00	1.01	Small Fab - 1		SMB 19/8/19
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	1 pcs	8/16/19	8/16/19	0.00	0.00	QC 5 - 10		DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		AUG 12 2019
							QC 5 - 61		
							QC 5 - 81		
125	Packaging 1-1 - Pick Kit - B4B	1 pcs	8/16/19	8/16/19	0.00	0.00	Packaging 1 - 1 - B4B		TUE 8-13-2019 → Oscar
							Packaging 1 - 2 - B4B		
							Packaging 1 - 3 - B4B		

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				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36	
130 QC 4	1 pcs	8/16/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	DAS
				QC 4 - 9	75
				QC 4 - 46	9-89
				QC 4 - 68	
				QC 4 - 72	8/13/2019
				QC 4 - 74	
				QC 4 - 75	
140 Packaging 3-1 - Stock - B4B	1 pcs	8/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	75
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	8/13/2019
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	

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				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
145	DC - 1 - B4B	1 pcs	8/16/19	0.00 0.00	DC - 1 - B4B
					DC - 2 - B4B
150	QC 21 - FG	1 pcs	8/16/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53
Part Op 110 - (Small Fab) Assemble as per Dwg D206-558 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O) 125 - (Pick Kit) 130 - (QC4- 100% Inspect kits for completeness) 140 - Identify and pack for shipping as per PPP D407-558-045 LOCATION: FG011 145 - (Document Control) Photocopy bluefile and type labels as per PPP D407-558-045 CHG003 150 - (QC21- Final Inspection - Work Order Release)					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2011-101	Mirror 6"	1 pcs (1 ea)	110-Small Fab - 1	5184871
D2052	Bracket	2 pcs (2 ea)	110-Small Fab - 1	5190928
D2054	Bushing - Delrin	2 pcs (2 ea)	110-Small Fab - 1	5198669
D2055	Clamp	1 pcs (1 ea)	110-Small Fab - 1	5187287
D2056	Bell Crank Assembly	1 pcs (1 ea)	110-Small Fab - 1	5089342
D2057	Plug	1 pcs (1 ea)	110-Small Fab - 1	5197307
D2065	Mirror Arm	1 pcs (1 ea)	110-Small Fab - 1	5108202
MS21042L3	Nut	2 Ea (2 ea)	110-Small Fab - 1	5149299
MS27039-1-18	Screw	2 Ea (2 ea)	110-Small Fab - 1	F124326
NAS1149D0363J	Washer	4 Ea (4 ea)	110-Small Fab - 1	5191331
AN3-4A	Bolt	4 Ea (4 ea) ✓	125-Packaging 1-1 - Pick Kit - B4B	5167263 ✓
AN526-1032R9	Screw	4 Ea (4 ea) ✓	125-Packaging 1-1 - Pick Kit - B4B	5173054 ✓
D2053	Bracket	1 pcs (1 ea) ✓	125-Packaging 1-1 - Pick Kit - B4B	5114998 ✓
D2067	Connector	1 pcs (1 ea) ✓	125-Packaging 1-1 - Pick Kit - B4B	5143351 ✓
D2071-5	Cable	1 pcs (1 ea) ✓	125-Packaging 1-1 - Pick Kit - B4B	5099388 ✓
D3778-3	Bracket	1 pcs (1 ea) ✓	125-Packaging 1-1 - Pick Kit - B4B	5094742 ✓
MS21042L3	Nut	1 Ea (1 ea) ✓	125-Packaging 1-1 - Pick Kit - B4B	5204283 ✓
MS21919-DG5	Clamp	2 Ea (2 ea) ✓	125-Packaging 1-1 - Pick Kit - B4B	5171982 ✓
MS35489-67	Grommet	1 Ea (1 ea) ✓	125-Packaging 1-1 - Pick Kit - B4B	F121600 ✓
MS35489-9	Grommet	1 Ea (1 ea) ✓	125-Packaging 1-1 - Pick Kit - B4B	5113604 ✓
NAS1149D0332J	Washer	6 Ea (6 ea) ✓	125-Packaging 1-1 - Pick Kit - B4B	5178398 ✓

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	D2011-101	1	28	0
	D2052	2	9	0
	D2054	2	66	0
	D2055	1	16	0
	D2056	1	21	0
	D2057	1	22	0
	D2065	1	3	0
	MS21042L3	2	852	0
	MS27039-1-18	2	1,119	0
	NAS1149D0363J	4	1,767	0
125-Packaging 1-1 - Pick Kit - B4B	AN3-4A	4	420	0
	AN526-1032R9	4	208	0
	D2053	1	7	0
	D2067	1	41	0
	D2071-5	1	11	0
	D3778-3	1	5	0
	MS21042L3	1	852	0
	MS21919-DG5	2	60	0
	MS35489-67	1	15	0
	MS35489-9	1	19	0
	NAS1149D0332J	6	2,553	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			



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Container No: S203850



Part: D407-558-045

Job No: 198608

Serial No/Batch: S203850

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-17 Issue 7 and FAA STC SH1031NE 01/11/09, LBA GEI /

Change Record

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Part Number: D407-558-045

Description: SINGLE MIRROR INSTALLATION

[illegible]

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 206A/B/L/L1/L3/L4	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D206-558-043	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 206A/B/L/L1/L3/L4	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg
D407-558-045	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 407	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D407-558-047	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 407	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg

5.0 PARTS LIST

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X			D206-558-043	DUAL CARGO MIRROR ASSEMBLY
		X		D407-558-045	SINGLE CARGO MIRROR ASSEMBLY
			X	D407-558-047	DUAL CARGO MIRROR ASSEMBLY
1	2	1	2	D2011-101	MIRROR ASSEMBLY
2	2	2	2	D2052**	BRACKET
1	1	1	1	D2053	BRACKET
2	2	2	2	D2054**	BUSHING
1	1	1	1	D2055**	CLAMP
1	1	1	1	D2056**	BELLCRANK ASSEMBLY
1		1		D2057	PLUG
1		1		D2065	ARM
	1		1	D2066	ARM
1	1	1	1	D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	1	D2071-5	CABLE ASSEMBLY
1	2	1	2	D3014-1*	LOCKNUT
1	1			D3778-1	BRACKET
		1	1	D3778-3	BRACKET
4	4	4	4	AN3-4A	BOLT
4	4	4	4	AN526-1032R9	SCREW
1	2	1	2	NAS1149D0416P*	WASHER (AN960JD416L)
4	4	4	4	NAS1149D0363P**	WASHER (AN960JD10)
6	6	6	6	NAS1149D0332P	WASHER (AN960JD10L)
3	1	3	1	MS21042-3	NUT (or MS21042L3)
	2		2	MS21042-3**	NUT (or MS21042L3)
2	2	2	2	MS21919DG5	CLAMP
2	2	2	2	MS27039-1-18**	SCREW
1	1	1	1	MS35489-9	GROMMET
1	1	1	1	MS35489-67	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

** INCLUDED AS PART OF D2066 ARM (REF. -043/-047 ONLY)

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Revision: D

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